

Date: Wednesday, 15/08/2007 4:00:20 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 33937		
Estimate Number	: 10267		
P.C. Number	: N/A	Part Number	: D2438
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: D2438 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 32016	Material	: N/A
Written By	: <u>W</u>	Due Date	: 31/08/2007
Checked & Approved By	: <u>W</u>	Qty:	200 Um: Each
Comment	: Est: E 05.06.28 Bending removed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4371

Laser cut as per Dwg D2438

Material release note is required

C267103/14

W

(200)

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

2/9/18 SQ

(200X)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

QSP019

En 07/02/19

counters

(200)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

SAN

07/09/23

counted

(201)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 33937

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/24 (201)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/24 (201)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(201)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/25

Job Completion



u 07/09/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

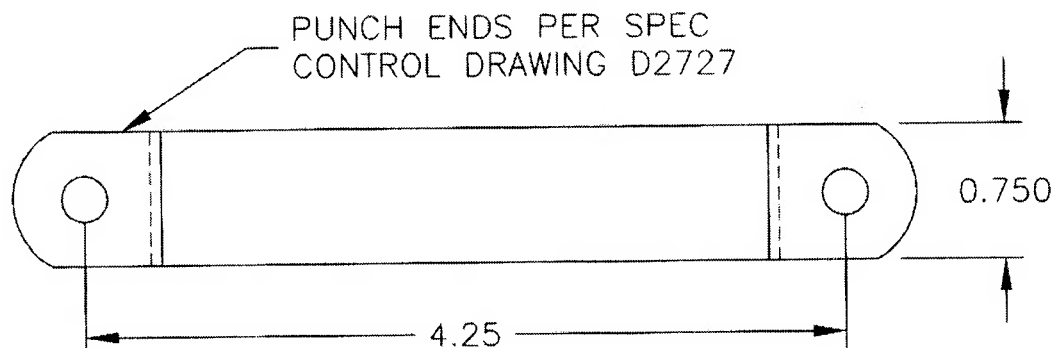
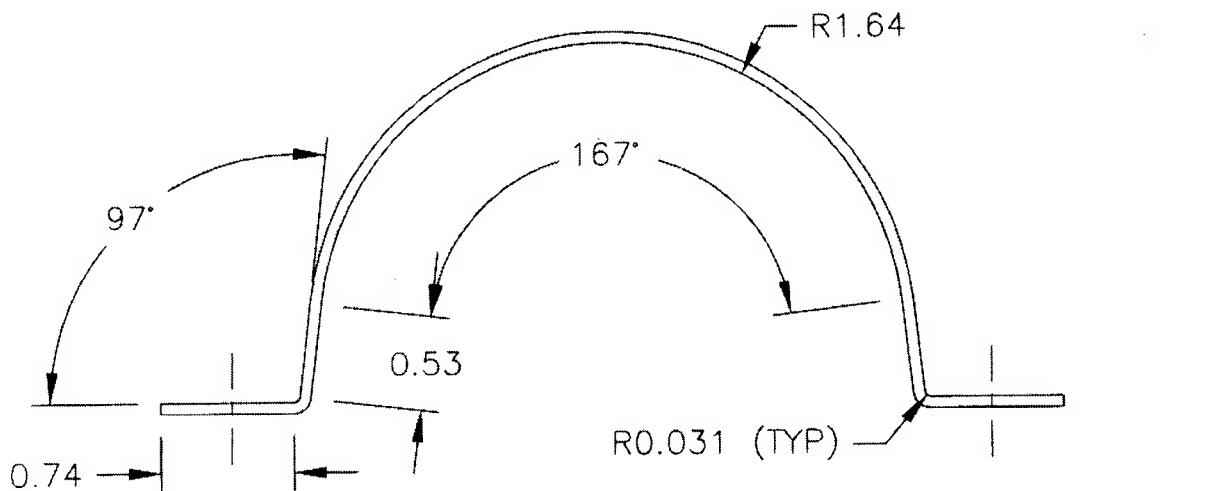
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>CS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
19.06.17 KE



W/O: 33937

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

20 46 06
CP 20 46 07

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

1811 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	11	OUR JOB NO	J0167069	SHIPPING MEMO	0373992	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
1	200 PCS	PO00004371	D2438B	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SIGMA METALS		824074		
PROCESS		PROCESSOR		RELEASE NOTE #		
1	FIRST ARTICLE INSPECTION REPORT ON FILE		GFI		CONFORMS	
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE: 14 SEPTEMBER 2007

G.F.I. Q.C. REP.



Sigma Metals Inc.

45 Jeffry Blvd.

Deer Park, NY 11729

A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Packing Slip

DATE 2/27/2007 INVOICE NO. 43030

BILL TOGFI INC.
110 AVENUE LABROSSE
POINT-CLAIRE
QUE, CANADA
H9R 1A1**SHIP TO**GFI INC.
180 AVENUE LABROSSE
POINT-CLAIRE
QUE, CANADA
H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
1070988	Net 30	MEC	YELLOW	DEER PARK, NY	59828

ITEM	DESCRIPTION	QTY
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SS SHEET

304 STAINLESS STEEL SHEET
ANNEALED

AMS 5513

.063" X 48" X 36"

189 LBS.

MILL: ATI LOT# 824074

REPLACEMENT

NRE 4680

BOXING CHARGE

6

BOXING

GFI INC.

LE MATERIEL RECU NE SERA ACCEPTE
QU'APRES VERIFICATION DE DIMENSIONS
EPAISSEUR, POIDS ET CONDITIONS

SIGNATURE

DATE 01 MAR 07

CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW. IF THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED.

Gregory Saladin

Quality Control Manager

TEST REPORTS WITH SHIPMENT

MASTERCARD AND AMERICAN EXPRESS

NOTICE OF SHIPMENT/
PACKING LIST

CERTIFICATE OF TEST

SOLD TO →		FORMS DISTRIBUTION SHIP TO →		SPEC →		CUST. CODE 08/18/06 110977		ACCEPTING MILL NEW CASTLE, IN.		SHIPPER NO. 524046		PRODUCT CODE 13020102060000		MILL ORDER NUMBER 30-096-051		DATE SHIPPED 12/12/06	
						REPEAT ORDER 82037-4		DO RATE 26		GOVT CONTRACT		MATL 11.24		SHIPPING LOCATION NEW CASTLE		INVOICE 072704	
						PRIME SEC.		DSO DSO									
						584											

GRADE AND SPECIFICATIONS
 ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

CARRIER - BOHREN LOGISTICS, INC.

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001	1	48./062/2129.	824074	11066N273	7732493	21585	60	21525		150974		
IF POSSIBLE SHIP WITH LOAD 4111 TO DEL 12/12												
C CUST IDENTITY 00640												
1 SKID												
						21585	60	21525				

TYPE HEAT/TEST	--C--	--MN--	--P--	--S--	--SI--	--CR--	--NI--	--MO--	--CU--	--N--
HEAT 824074	.021	1.29	.034	.001	.35	18.28	8.03	.40	.45	.05

ITEM TEST NO	YIELD PSI *	TENSILE PSI	% ELONG IN 2"	% R/A	HARDNESS 83.HRB	BEND T PASS	CORROSION A 262 PR E	GRAIN SIZE 8.
001 7732493	T 47400.	92500.	58.		82.HRB		PASS	

* Y.S. BY 0.2% OFFSET METHOD

ITEM TEST NO	MELT SOURCE	P&W E-25 TRAN BEND
001 7732493	1.	2.

METALLOGRAPHIC MAGNIFICATION: 100X ETCHANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

REVIEWED BY Q.C.

Date 12/18/06 by CC

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE-Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires, veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

C. M. Napoli
Manager, Technical Information

DART

Purchase Order

Date
Aug 16, 2007

Page
1

Purchase Order Number
PO00004371

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
09/20/07

Vendor Address:

GFI
180 Avenue Labrosse
Prince Claire, QC H9R 1A1
Phone (514) 630-4877
Fax (514) 630-4849

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arriv.
		VC-GFI001	Aug 16, 2007	N30	Purolator	Aug 31, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
200.0000	D2438B 150 4/9/10 54	Clamp Comments: CUT & FORMED AS PER DWG D2438 REV. C B33937	8/31/2007	No	3.250000	Each	650.0
100.0000	D2171F ✓ 7/9/17 54	Clamp Comments: AS PER DWG D2171 REV. D CUT & FORMED B33936	8/31/2007	No	5.750000	Each	575.0

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:

Tax Summary:

GST 73.50
GSTME 0.00
GSTND 0.00

Less:
included tax

0.00

Subtotal

1,225.00

Total tax

73.50

Entered By: CL CLAVOIE